

Work Order ID 119834

119834

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May-27-14 11:31:02 AM

Item ID: D5032-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 5/27/14

Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5032

A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

DAS

37

9-89 14.06.01

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

DAS

37

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Stop *NR2*

can

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Item ID: D5032-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 5/27/14 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>5T129</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

60x DAS 28 JUN 04 2014 9-89

MLJ 14-06-04

AA 14-6-4

Picklist Print

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Work Order ID: 119834

119834

Parent Item: D5032-1

D5032-1

Parent Item Name: Doubler

Start Date: 5/27/14

Required Date: 5/30/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

316.9200

2

M6061T6S 040

**

mm 14/06/01

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

316.92

m126350

22.52

m126981

76.91

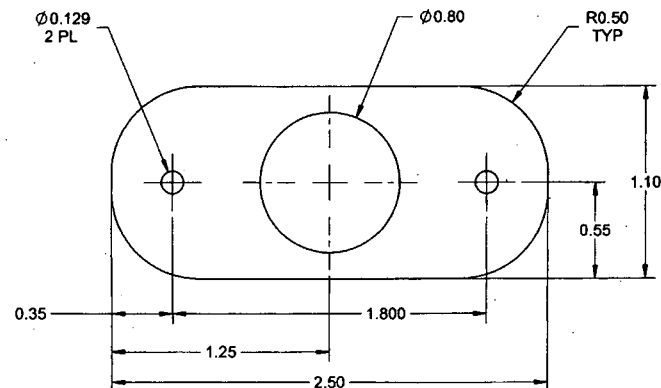
m128422

49.79

m129165

167.7

1.5



D5032-1 DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED
2013-12-23

ASS ECU 13-705

A		NEW ISSUE		RF	13.12.09
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	DC	DRAWING NO.	REV. A		
MFG. APPR.	DC	D5032	SHEET 1 OF 2		
APPROVED	DC	TITLE	SCALE		
DE APPR.	DC	DOUBLER	NTS		
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